

Work Order ID 51992

September 11, 2009 10:14:10 AM



Page 2

Item ID: D3884-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle, Inboard RH

Start Date: 09/14/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/23/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

Sh 09/09/22

2

0

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

09-09-22

(2)

HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1112260

0.00

7/11 09/09/23

(2)

0

Powdercoat

Memo

START TIME: *9:00am*
OVEN TEMPERATURE: *320°F*
FINISH TIME: *9:30am*

Powder Coating

Work Order ID 51992

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Page 3

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Cust Item ID:

Required Date: 09/23/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

Bl 09-09-23

(2)



QC

Memo

Quality Control

160

Identify as per dwg & Stock Location: *429*

0.00



Packaging

Memo

Packaging

0.00

9/9/23 (22) J

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

09/09/24 J



MF 09-09-24

September 11, 2009 10:14:10 AM

[illegible]

Required Date: 09/23/2009

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-017RevB		Manufactured	No			100	Each	0.0000	4.0000			
											47460	
Saddle Billet												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51992
Description: Saddle, In Board RH		Part Number: J3484-2
Inspection Dwg: 3484	Rev: B	Page 1 of 2

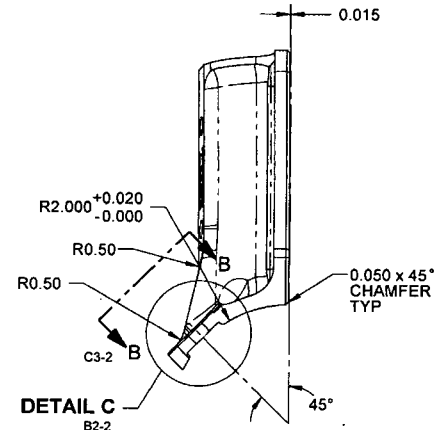
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	±.005	3.900	/			
1.438	"	1.439	/			
2.875	"	2.875	/			
2.250	"	2.249	/			
1.125	"	1.124	/			
Ø.257	+ .005 - .000	.258	/			
.140/.175	✓	.150	/			
.110/.140	✓	.140	/			
.648	±.010	.649	/			
.615	±.010	.616	/			
.125	"	.127	/			
.250	"	.252	/			
1.265	+ .020 - .000	1.273	/			
.110/.140	✓	.140	/			
.140/.165	✓	.148	/			
2.356	±.030	2.378	/			
Ø.75	"	.750	/			
1.000	±.010	1.006	/			
1.750	±.005	1.750	/			
.500	±.010	.500	/			
.625	"	.624	/			
1.250	"	1.251	/			
1.250	±.005	1.251	/			



Measured by: JS	Audited by: SA	Prototype Approval:	N/A
Date: 09/09/21	Date: 09/09/22	Date:	N/A

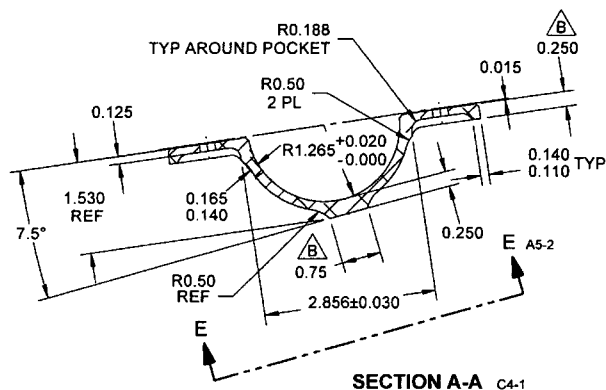
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[illegible]

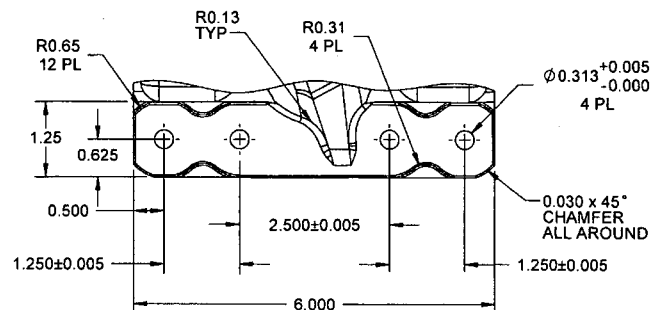
D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)

- NOTES:**
- B** 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

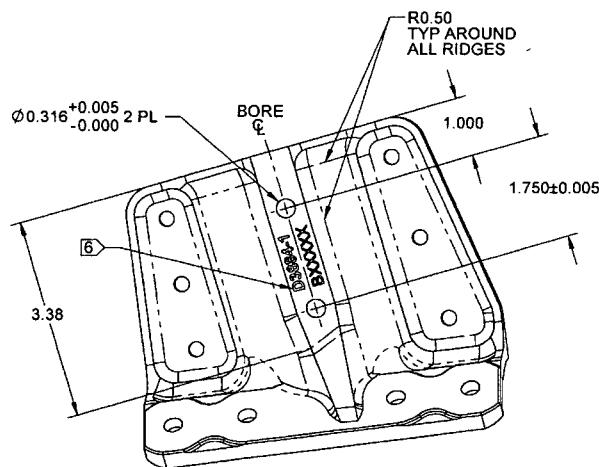
B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE, ZN C4-2; ADD R0.031, ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165, ZN B7-1; ADD 0.615, ZN C6-1; ADD 0.848, ZN C4-1; ADD 0.250, ZN D6-2; ADD 0.080, ZN C2-2; 0.75 WAS 0.65, ZN D7-2		RF	09.06.30
A	NEW ISSUE		RF	09.03.30
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN	RF	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3884	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		INBOARD SADDLE	NTS	
DATE	09.06.30		COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR REPRODUCED IN ANY MANNER BY ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	



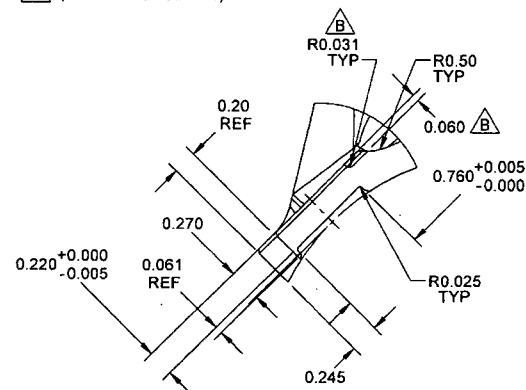
SECTION A-A C4-1



VIEW B-B B3-1
(ROTATED FOR CLARITY)



VIEW E-E C6-2



DETAIL C B3-1
SCALE 2X

RELEASED
09/15/10

51992

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3884	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	INBOARD SADDLE	NTS
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